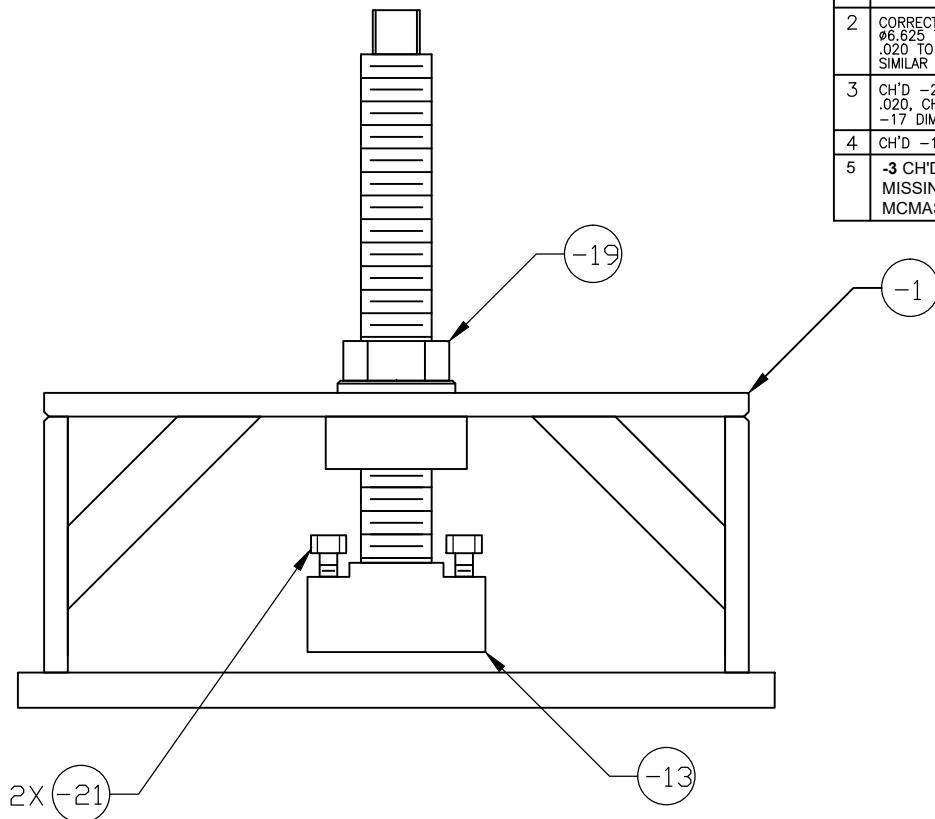


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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	ADDED MISSING DIM. 1.000 -17, CH'D -5 LENGTH IN BOM TO 7-3/4. CH'D THICKNESS -3 FROM .250 TO (.375) & CH'D BOM THICKNESS FROM 1/2 TO 3/8, ADDED 4 EA. Ø1/8 x 1/4 ROLL PINS -23. CH'D OVERALL HEIGHT -1 FROM 3.020 TO 3.165 +1/32-1/8, ADDED Ø.125 HOLES FOR ROLL PINS ON -3, -5, -7, ADDED FIT TO -11 FOR WELDING TO Ø1.500 COUNTERBORE. CH'D WELD AT -3 & -7. ALL CHANGES PER S.E., G.E.	1/13/11	RJC RW
2	CORRECTED -3 Ø.210 HOLE LOCATIONS, CH'D O.D. FROM Ø8.040 TO Ø8.00, CH'D I.D. FROM Ø6.625 TO Ø6.630, CH'D LOCATION OF AFT & FWD TEXT PER S.E. ADDED FLATNESS TOLERANCE .020 TO -1 PER G.E. CORRECTED -5 ENGRAVE NOTE. MOVED DOWEL PIN HOLES TO MATCH SIMILAR MANUFACTURED PART PER G.E.	3/11/11	RJC SE
3	CH'D -23 FROM STEEL, ASSEMBLED OVERALL HEIGHT -1 CH'D FROM 3.165 & FLATNESS FROM .020, CH'D -3, -5, -7, -15 DIMENSIONS TO MEET FACTORY PART, CH'D -11 DESIGN, CH'D -17 DIMENSION BETWEEN HOLES FROM 1.440 PER S.E.	12/13/11	RJC SE
4	CH'D -1 FLATNESS TOLERANCE FROM .003 TO .010 PER G.E.	3/1/12	RJC GE
5	-3 CH'D TOLERANCE ON DIM WAS Ø6.630 IS Ø6.630 +.003-.000. -11 ADDED MISSING DIM .03 X 45°. -19 CH'D B/O INFO WAS MCMASTER-CARR #90499A640 IS MCMASTER-CARR #94895A840.	4/28/14	DPD GE



ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
		X		-1	1 WELDMENT			2
		1		-3	1 BASE	1018	3/8 x 8-1/4 x 8-1/4	3
		1		-5	1 PLATE	1018	1/4 x 2 x 7-5/8	4
		2		-7	1 LEG	1018	1/4 x 2 x 2-7/8	5
		2		-9	1 GUSSET	1018	1/4 x 5/8 x 3	6
		1		-11	1 BUSHING	1018	Ø1-1/2 x 1-1/16	7
		X		-13	1 WELDMENT			8
		1		-15	1 BOLT	ALL THREAD	3/4-16 UNF x 7-1/16	9
		1		-17	1 HEAD	1018	1 x 1-1/4 x 2	10
		B/O	-19	1	1 HEX NUT	STEEL	3/4-16 UNF MCMASTER-CARR #94895A840	1
			-21	2	2 HEX HEAD CAP SCREW	STEEL	10-32 UNF x 5/8 AIRCRAFT SPRUCE #AN3-5A	1
			-23	8	8 ROLL PIN	S.S.	Ø1/8 x 1/4 MCMASTER-CARR #92373A173	1
ASSY -13	ASSY -1							

NOTE:  
TOOL PART OF KIT RBW6305G01331-3G.

RB RED BARN MACHINE

TITLE REACTION CLUTCH IN RACE REMOVAL

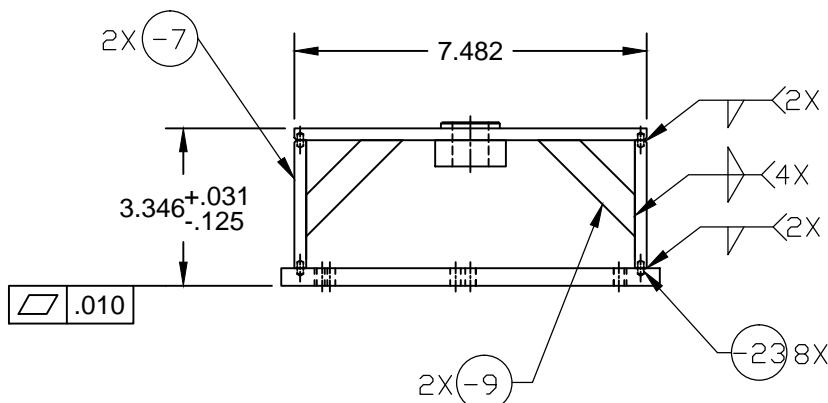
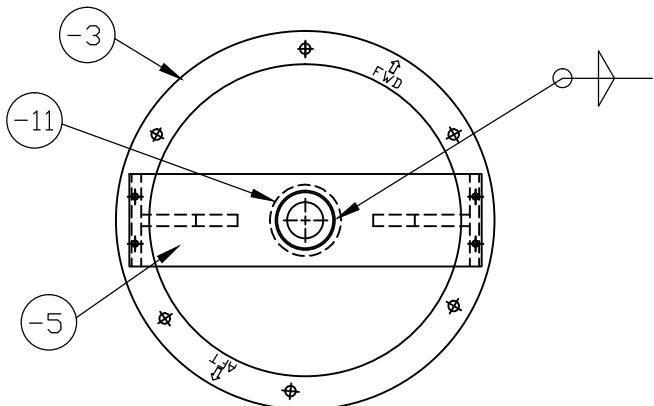
DWG NO. RBW6305G03031-3G REV 5

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: CLOUGH APPROVED D Weil HEAT TREAT FINISH SPEC USED ON MODEL AW139
1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R. 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	

SCALE 1:2 DATE 3-30-10 SHEET 1 of 10

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REV	DESCRIPTION	REVISIONS		
		DATE	INITIAL	APPROVED
1	ADDED MISSING DIM. 1.000 -17, CH'D -5 LENGTH IN BOM TO 7-3/4. CH'D THICKNESS -3 FROM .250 TO (.375) & CH'D BOM THICKNESS FROM 1/2 TO 3/8, ADDED 4 EA. Ø1/8 x 1/4 ROLL PINS -23. CH'D OVERALL HEIGHT -1 FROM 3.020 TO 3.165 +1/32-1/8, ADDED Ø.125 HOLES FOR ROLL PINS ON -3, -5, -7, ADDED FIT TO -11 FOR WELDING TO Ø1.500 COUNTERBORE. CH'D WELD AT -3 & -7. ALL CHANGES PER S.E., G.E.	1/13/11	RJC	RW
2	ADDED FLATNESS TOLERANCE .020 TO -1 PER G.E.	3/11/11	RJC	SE
3	ASSEMBLED OVERALL HEIGHT -1 CH'D FROM 3.165 & FLATNESS FROM .020 PER S.E.	12/13/11	RJC	SE
4	CH'D -1 FLATNESS TOLERANCE FROM .003 TO .010 PER G.E.	3/1/12	RJC	GE

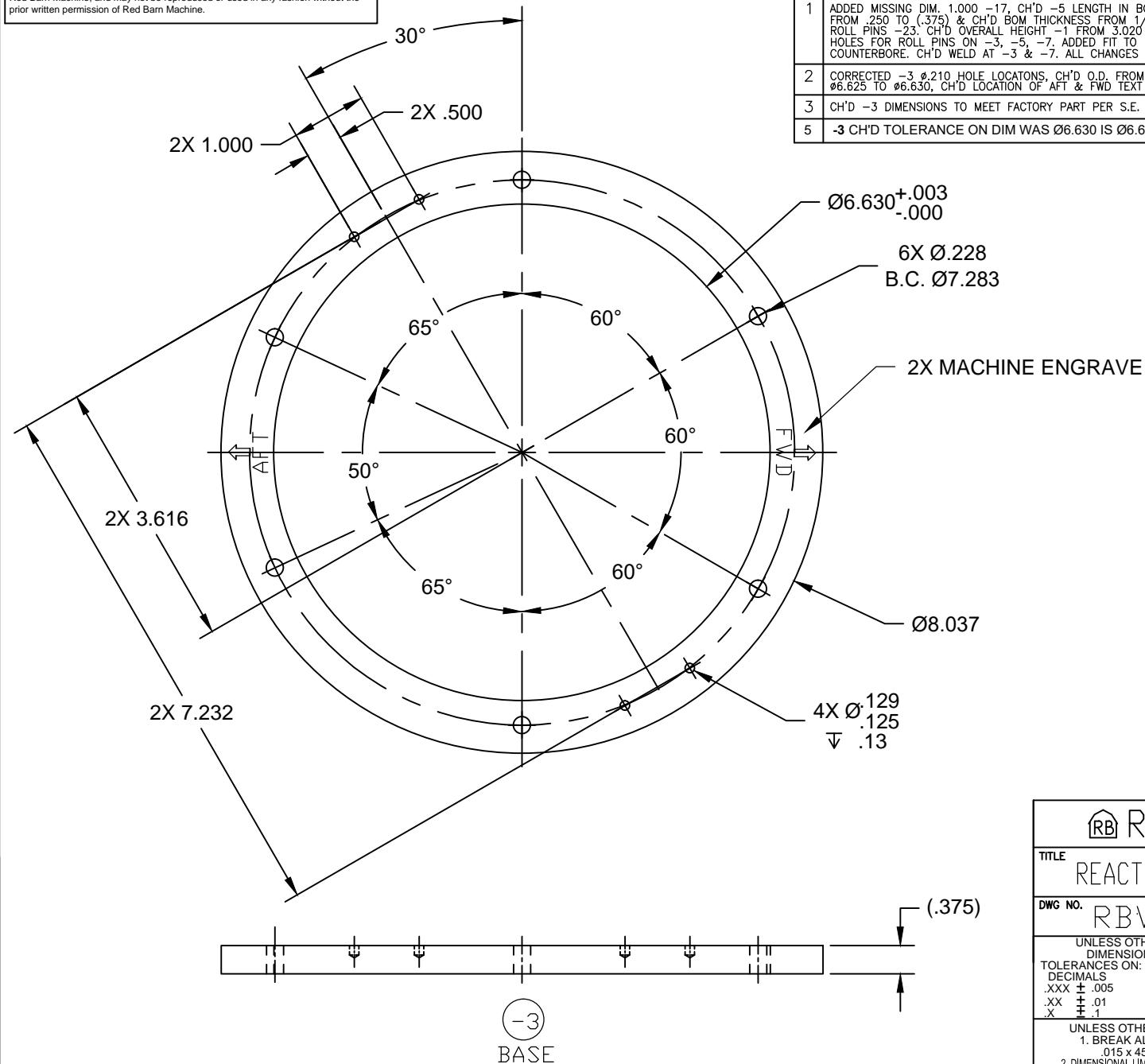


(-1)  
WELDMENT

RED BARN MACHINE	
TITLE REACTION CLUTCH IN RACE REMOVAL	
DWG NO. RBW6305G03031-3G-1	REV 5
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 1° .X ± .1	
DRAWN BY: CLOUGH APPROVED D Weil HEAT TREAT FINISH CAD PLATE YELLOW SPEC QQ-P-416F, TYPE II CLASS II USED ON MODEL AW139	
SCALE 1:3	DATE 3-30-10
SHEET 2 of 10	

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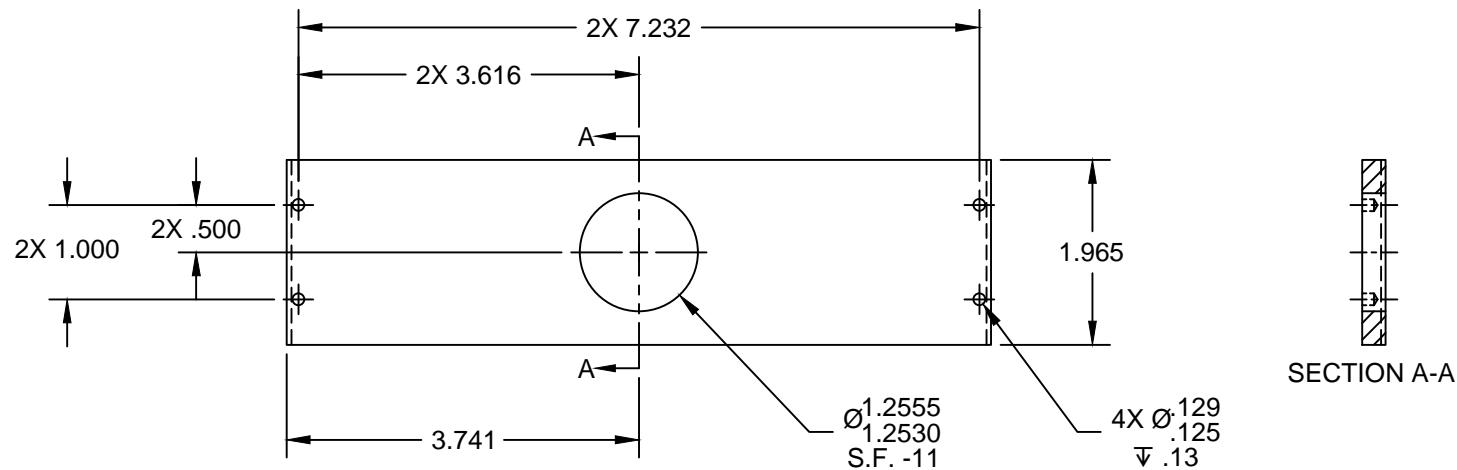
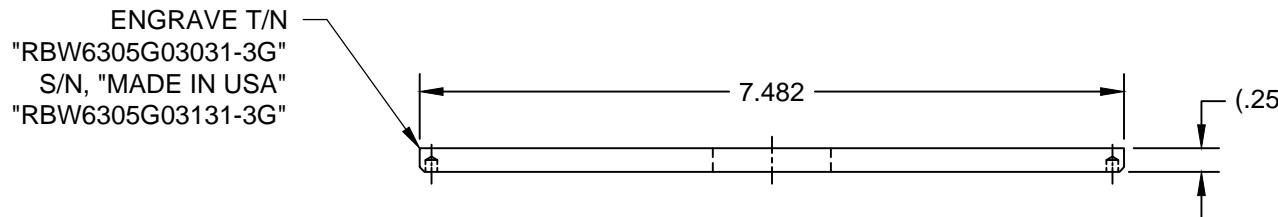
REVISIONS		
REV	DESCRIPTION	DATE
		INITIAL
1	ADDED MISSING DIM. 1.000 -17, CH'D -5 LENGTH IN BOM TO 7-3/4. CH'D THICKNESS -3 FROM .250 TO (.375) & CH'D BOM THICKNESS FROM 1/2 TO 3/8, ADDED 4 EA. Ø1/8 x 1/4 ROLL PINS -23. CH'D OVERALL HEIGHT -1 FROM 3.020 TO 3.165 +1/32-1/8, ADDED Ø.125 HOLES FOR ROLL PINS ON -3, -5, -7, ADDED FIT TO -11 FOR WELDING TO Ø1.500 COUNTERBORE. CH'D WELD AT -3 & -7. ALL CHANGES PER S.E., G.E.	1/13/11
2	CORRECTED -3 Ø.210 HOLE LOCATIONS, CH'D O.D. FROM Ø8.040 TO Ø8.00, CH'D I.D. FROM Ø6.625 TO Ø6.630, CH'D LOCATION OF AFT & FWD TEXT PER S.E.	3/11/11
3	CH'D -3 DIMENSIONS TO MEET FACTORY PART PER S.E.	12/13/11
5	-3 CH'D TOLERANCE ON DIM WAS Ø6.630 IS Ø6.630 +.003 -.000.	4/28/14



RED BARN MACHINE	
TITLE: REACTION CLUTCH IN RACE REMOVAL	
DWG NO.	REV 5 RBW6305G03031-3G-3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005      FRACTIONS ± 1/32 .XX ± .01      ANGLES ± 1° .X ± .1	
DRAWN BY: CLOUGH APPROVED: <i>D. Weil</i>	
HEAT TREAT:	
FINISH SEE -1 WELDMENT	
SPEC:	
USED ON MODEL AW139	
SCALE	1:2
DATE	3-30-10
SHEET	3 of 10

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	ADDED MISSING DIM. 1.000 -17, CH'D -5 LENGTH IN BOM TO 7-3/4. CH'D THICKNESS -.3 FROM .250 TO (.375) & CH'D BOM THICKNESS FROM 1/2 TO 3/8, ADDED 4 EA. Ø1/8 x 1/4 ROLL PINS -23. CH'D OVERALL HEIGHT -1 FROM 3.020 TO 3.165 +1/32-.1/8, ADDED Ø.125 HOLES FOR ROLL PINS ON -.3, -.5, -.7, ADDED FIT TO -.11 FOR WELDING TO Ø1.500 COUNTERBORE. CH'D WELD AT -.3 & -.7. ALL CHANGES PER S.E., G.E.	1/13/11	RJC RW
2	CORRECTED -.5 ENGRAVE NOTE, MOVED DOWEL PIN HOLES TO MATCH SIMILAR MANUFACTURED PART PER G.E.	3/11/11	RJC SE
3	CH'D -5 DIMENSIONS TO MEET FACTORY PART PER S.E.	12/13/11	RJC SE

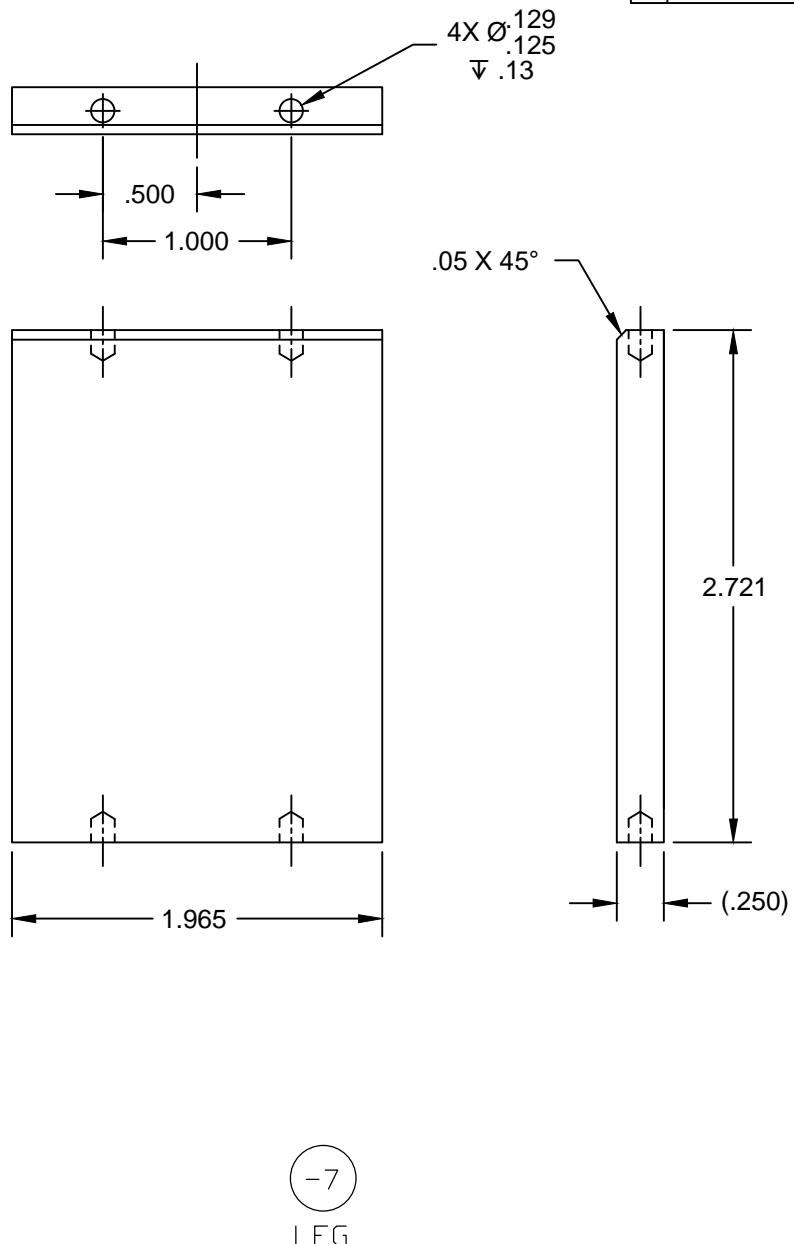


(-5)  
PLATE

RED BARN MACHINE	
TITLE	
REACTION CLUTCH IN RACE REMOVAL	
DWG NO.	REV 5
RBW6305G03031-3G-5	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32	ANGLES ± 5°
HEAT TREAT	FINISH SEE -1 WELDMENT
SPEC	USED ON MODEL
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. 015 R. 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 3-30-10
SHEET 4 of 10	
AW139	

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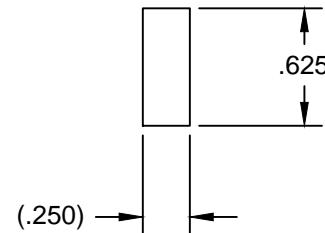
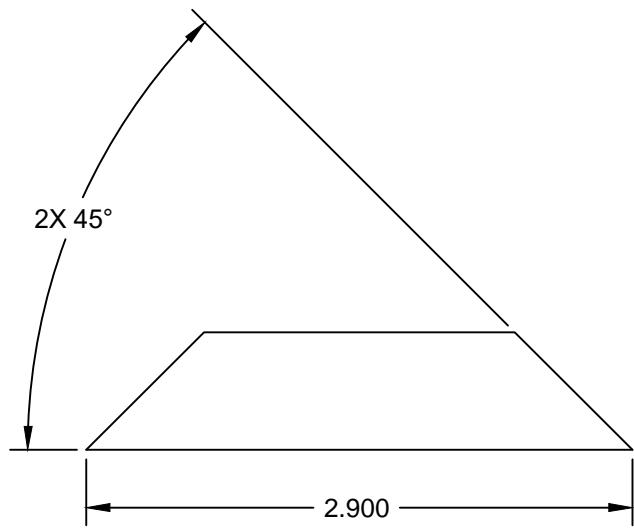
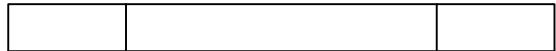
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	ADDED MISSING DIM. 1.000 -17, CH'D -5 LENGTH IN BOM TO 7-3/4. CH'D THICKNESS -.3 FROM .250 TO (.375) & CH'D BOM THICKNESS FROM 1/2 TO 3/8, ADDED 4 EA. Ø1/8 x 1/4 ROLL PINS -23. CH'D OVERALL HEIGHT -1 FROM 3.020 TO 3.165 +1/32-.1/8, ADDED Ø.125 HOLES FOR ROLL PINS ON -.3, -.5, -.7, ADDED FIT TO -.11 FOR WELDING TO Ø1.500 COUNTERBORE. CH'D WELD AT -.3 & -.7. ALL CHANGES PER S.E., G.E.	1/13/11	RJC RW
3	CH'D -7 DIMENSIONS TO MEET FACTORY PART PER S.E.	12/13/11	RJC SE



RED BARN MACHINE	
TITLE: REACTION CLUTCH IN RACE REMOVAL	
DWG NO.	REV 5
RBW6305G03031-3G-7	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005      FRACTIONS ± 1/32 .XX ± .01      ANGLES ± .5°	
HEAT TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R. 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	
AW139	
SCALE 1:1	DATE 3-30-10
SHEET 5 of 10	

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REV		DESCRIPTION		DATE	INITIAL	APPROVED

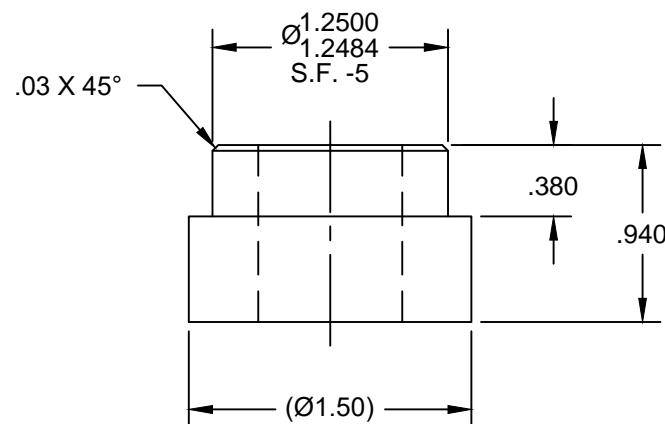
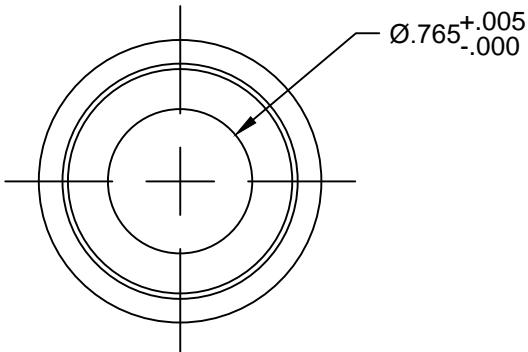


-9  
GUSSET

RED BARN MACHINE	
TITLE	
REACTION CLUTCH IN RACE REMOVAL	
DWG NO.	RBW6305G03031-3G-9
REV	5
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS	
.XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ± .5°
.X ± .1	
DRAWN BY: CLOUGH	
APPROVED	<i>D. Weil</i>
HEAT TREAT	
FINISH	SEE -1 WELDMENT
SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R. 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	
AW139	
SCALE	1:1
DATE	3-30-10
SHEET	6 of 10

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REV		DESCRIPTION		DATE	INITIAL	APPROVED
3		CH'D -11 DESIGN PER D.W.		12/13/11	RJC	SE
5		-11 ADDED MISSING DIM .03 X 45°.		4/28/14	DPD	GE

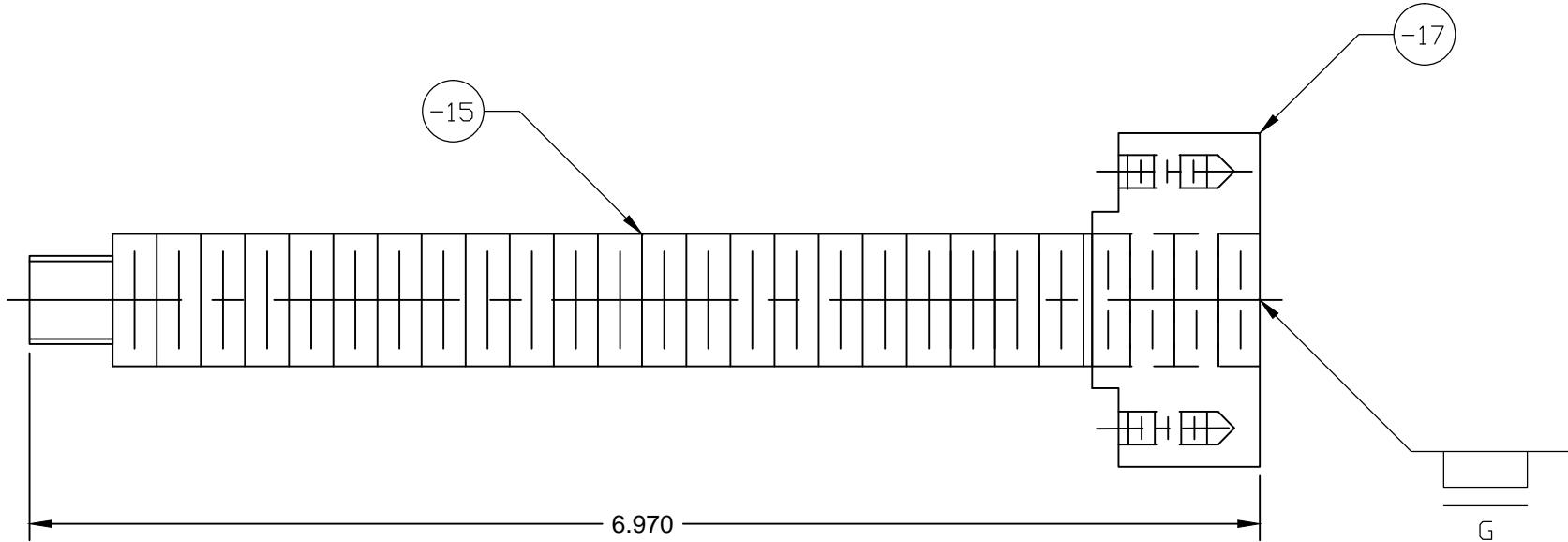


-11  
BUSHING

RED BARN MACHINE	
TITLE	
REACTION CLUTCH IN RACE REMOVAL	
DWG NO.	RBW6305G03031-3G-11
REV	5
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005      FRACTIONS ± 1/32	
.XX ± .01      ANGLES ± .5°	
.X ± .1	
HEAT TREAT	
FINISH SEE -1 WELDMENT	
SPEC	
DRAWN BY: CLOUGH	
APPROVED	
USED ON MODEL	
AW139	
SCALE	1:1
DATE	3-30-10
SHEET	7 of 10

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REV		DESCRIPTION		DATE	INITIAL	APPROVED

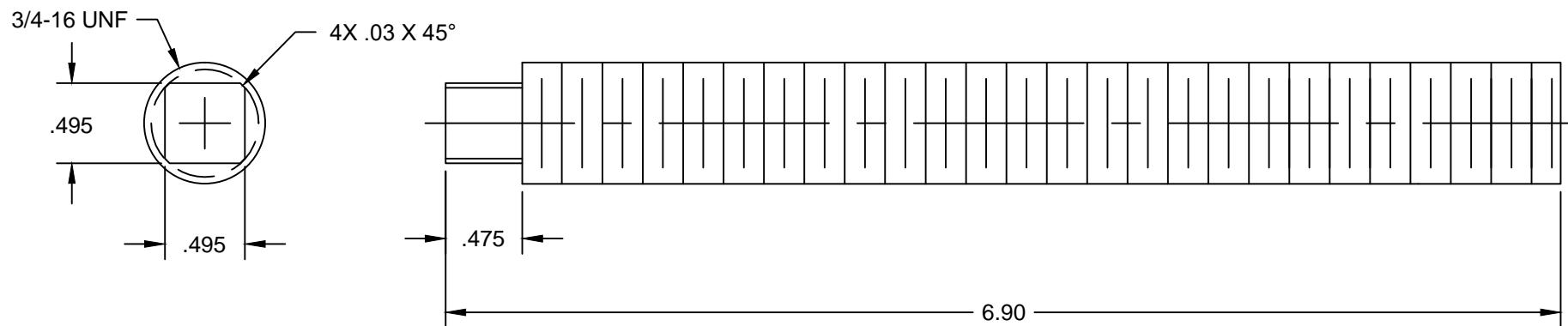


-13  
WELDMENT

RED BARN MACHINE	
TITLE	
REACTION CLUTCH IN RACE REMOVAL	
DWG NO.	RBW6305G03031-3G-13
REV	5
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005      FRACTIONS ± 1/32 .XX ± .01      ANGLES ± .5°	
DRAWN BY:	CLOUGH
APPROVED	<i>D. Weil</i>
HEAT TREAT	
FINISH	CAD PLATE YELLOW
SPEC	QQ-P-416F, TYPE II CLASS II
USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
AW139	
SCALE	1:1
DATE	3-30-10
SHEET	8 of 10

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REV		DESCRIPTION		DATE	INITIAL	APPROVED
3		CH'D -15 DIMENSIONS TO MEET FACTORY PART PER S.E.		12/13/11	RJC	SE



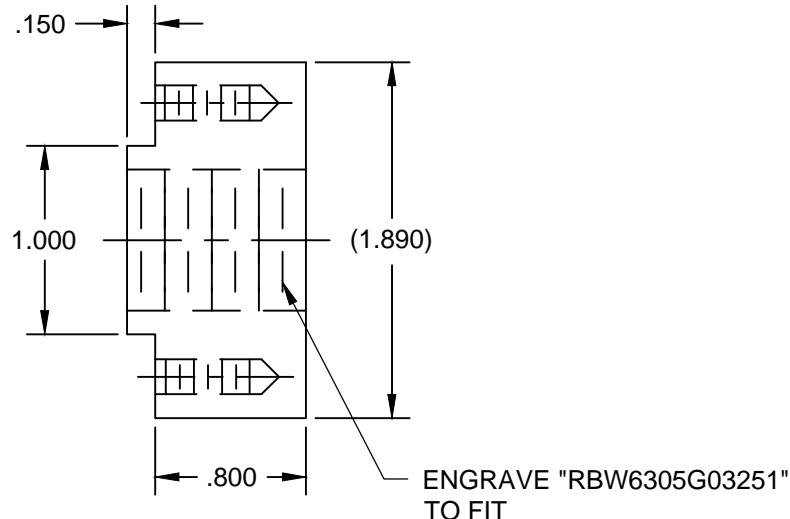
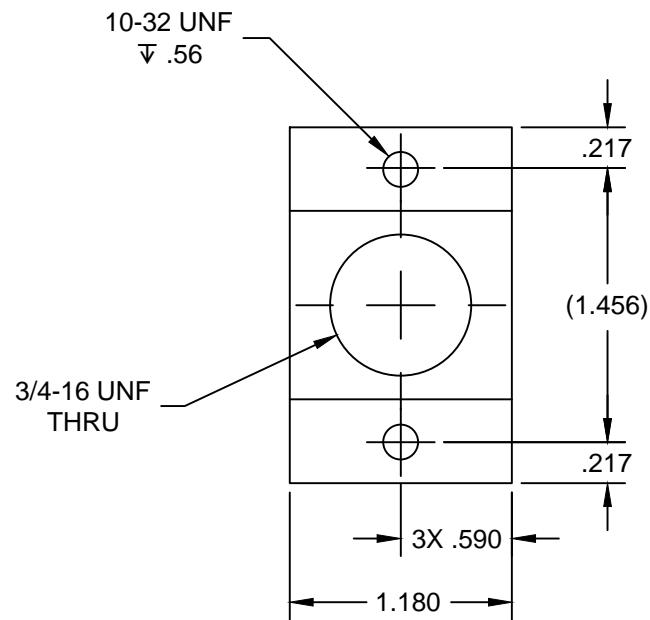
-15

BOLT

RED BARN MACHINE	
TITLE: REACTION CLUTCH IN RACE REMOVAL	
DWG NO:	RBW6305G03031-3G-15
REV	5
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005      FRACTIONS ± 1/32 .XX ± .01      ANGLES ± .5°	
DRAWN BY:	CLOUGH
APPROVED:	D Weil
HEAT TREAT:	
FINISH:	SEE -13 WELDMENT
SPEC:	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL:	AW139
SCALE:	1:1
DATE:	3-30-10
SHEET:	9 of 10

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	ADDED MISSING DIM. 1.000 -17, CH'D -5 LENGTH IN BOM TO 7-3/4. CH'D THICKNESS -3 FROM .250 TO (.375) & CH'D BOM THICKNESS FROM 1/2 TO 3/8, ADDED 4 EA. Ø1/8 x 1/4 ROLL PINS -23. CH'D OVERALL HEIGHT -1 FROM 3.020 TO 3.165 +1/32-1/8, ADDED Ø.125 HOLES FOR ROLL PINS ON -3, -5, -7, ADDED FIT TO -11 FOR WELDING TO Ø1.500 COUNTERBORE. CH'D WELD AT -3 & -7. ALL CHANGES PER S.E., G.E.	1/13/11	RJC RW
3	CH'D -17 DIMENSION BETWEEN HOLES FROM 1.440 PER S.E.	12/13/11	RJC SE



(-17)

HEAD

RED BARN MACHINE	
TITLE	
REACTION CLUTCH IN RACE REMOVAL	
DWG NO.	RBW6305G03031-3G-17
REV	5
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005      FRACTIONS ± 1/32 .XX ± .01      ANGLES ± 5°	
DRAWN BY: CLOUGH APPROVED D Weil	
HEAT TREAT	
FINISH SEE -13 WELDMENT	
SPEC	
USED ON MODEL	
AW139	
SCALE	1:1
DATE	3-30-10
SHEET	10 of 10